



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2571
Job Sheet 170900



Part No: D2571

Job Qty: 6 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/23/18

Job Tracking No:

Due Date: 2/16/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV F IPP: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/15/18	0.00	0.00	Start Up Machining		FK 18-2-1
100	CNC Vertical Machining	6 pcs		2/15/18	0.57	9.68	HAAS 1		FK SBL 18/02/03
110	Mill Conv	6 pcs		2/15/18	0.00	0.92	Mill Conv 1		FK SBL 18/02/03
120	QC	6 pcs		2/15/18	0.00	0.00	QC2		FK SBL 18/02/03
130	QC	6 pcs		2/15/18	0.00	0.00	QC8		J.P. 18-02-07
140	HandFinish	6 pcs		2/15/18	0.00	0.20	HandFinish1		09-02-07
150	Powdercoat	6 pcs		2/16/18	0.00	0.24	Powdercoat1		BR 18-02-08
160	QC	6 pcs		2/16/18	0.00	0.00	QC3		9-89 95
170	Packaging	6 pcs		2/16/18	0.00	0.00	Packaging3		9-89 95
180	QC21-SA	6 Ea		2/16/18	0.00	0.00	QC21		DAS FEB 12 2018

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per
Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and inspect
110 - Machine keyway as per dwg D2571 & D2572
120 - Inspect on CMM as per folio CMMA022.
150 - START TIME: 1:05 FINISH TIME: 1:35 O.V.T. 3:00 IN 138467.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	F165288-1

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Outboard	0.490Inches	0.510		

			+ 0.020	0.490
			- 0.000	
7	Saddle, Fwd Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Outboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Outboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Outboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Fwd Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Outboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure
Design	☐	Operator	Bending	☐	Set-up
Doc/Data	☐	Offset/Setup	Centre Not Concentric	☐	BOM/Route
Equip/Tooling	☐	Supplier	Cracks	☐	Broken/Damage/Defect
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material	☐	Use for Testing	Cuffs	☐	Contamination
Internal Transport	☐	Poor Information	Crushing	☐	Countersink
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Cut Too Short
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation	☐	Process Improvement	Marks/Chatter	☐	Drill Holes
Past Expiry Date	☐	Manufacturing Process			
Misidentified	☐	Past Due	OTHER :		

DART AEROSPACE LTD	Work Order:	170900
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.499	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.126	.126	.126	.126		
R	0.240	0.260		.252	.253	.253	.253		
S	0.115	0.135		.125	.125	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.238	.238		
W	0.115	0.135		.118	.120	.120	.118		
X	0.308	0.313		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.762		
Z	0.352	0.372		.364	.365	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject							DAS		

Measured by:	17K / 5BL
Date:	18-2-2 / 18/02/03

Audited by:	20
Date:	18-02-07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

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				1 5	2 6	3	4		
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		0.502	0.502				
G	0.257	0.262		0.257	0.257				
H	0.375	0.380		0.377	0.377				
I	0.490	0.510		0.500	0.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.569	0.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.875	3.875				
P	0.115	0.135		0.130	0.130				
Q	0.115	0.135		0.126	0.126				
R	0.240	0.260		0.252	0.252				
S	0.115	0.135		0.126	0.126				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.239	0.240				
W	0.115	0.135		0.120	0.120				
X	0.308	0.313		0.310	0.310				
Y	0.760	0.765		0.762	0.762				
Z	0.352	0.372		0.363	0.363				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.626	0.626				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.249	0.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.250	0.250				
AH	0.240	0.260		0.250	0.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043							
Accept/Reject									

Measured by: SBL	Audited by: DAS
Date: 18/02/03	Date: 20 18-02-07
	9-89

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B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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